

5/40

DART AEROSPACE LTD	Work Order:	24097
Description: End Plate	Part Number:	D3067-1
Drawing: D3067 Rev. A	Qty:	762 159

Page 1 of 1

RF 02/10/17 Stack of 8

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	PF	05.08.23	160
2	MV	Cut blanks 2.750" x 3.030" +/- 0.005 Grain along 2.750" Material: 5052-H32 (QQ-A-250/8) (M5052H32S.063) or 6061-T6 (QQ-A-250/11) (Ref. M6061T6S.063) Batch: M16454			
3	MV	Machine per folio FA183 and Dwg D3067	TNL	05/09/23	160
4	QC2	Inspect parts as they come off the CNC machine	TNL	05/09/23	160
5	QC7	Second inspection	CR	05/09/23	160
6	MV	Deburr			
7	GB	Bend as per Dwg D3067	SG	05/10/05	159
8	QC5	Inspect work to Step 7	SG	05-10-05	155
9	WA	Identify and stock	SG	05-10-05	155
10	AC	Cost / Part , 87	SGC	05-10-06	159
11	DC	Close W/O , 98 Inspect level 21	KD	05/10/06	159

PTD

Rev	Date	Change	Revised By	Approved
A	01.12.10	New Issue	EC	
B	02.01.03	Now machined on HAAS	SM	
C	02.10.04	Re-format	KJ RF	GL
C1	03.01.21	Remove step 6 (Deburr)	RF	GL

RELEASED
02/10/15 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-10-05	8	No parts scrapped during bending?? missing 1 end plate.		Count as <u>159</u>		✓ 05-10-05		✓ 05-10-05

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

No

DQA: 

Date: 05/10/06

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

DART AEROSPACE LTD	Work Order:	24f097
Description: End Plate	Part Number:	D3067-1
Inspection Dwg: D3067	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<i>gnt</i>	Audited by:	<i>JL</i>	Prototype Approval:	N/A
Date:	05/09/22	Date:	05.09.22	Date:	03.10.07

Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF	[Signature]

H:\FORMS\Quality Assurance\approved QA\FAI revD

RELEASED
03.10.07 AF

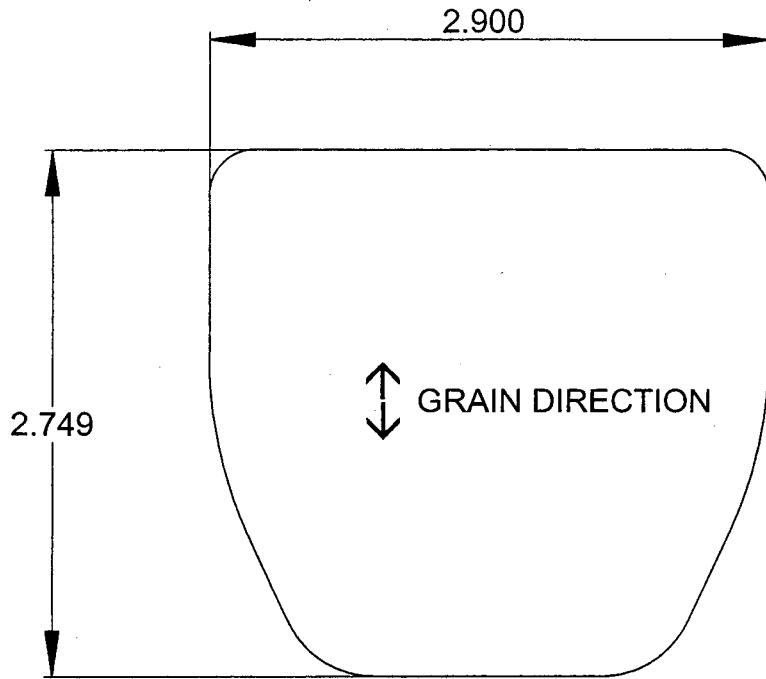


COPY ISSUED

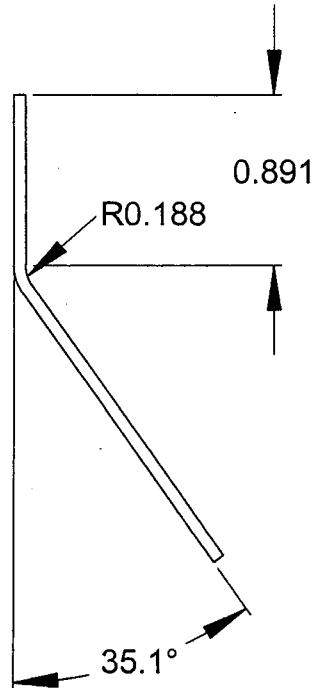
DESIGN <i>GP</i>	DRAWN BY <i>GP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JH</i>	APPROVED <i>JH</i>	DRAWING NO. D3067	REV. A SHEET 1 OF 1
DATE 02.09.11	TITLE END PLATE	SCALE 1:1	

RELEASED
02.04.2014

A 02.09.11 NEW ISSUE



D3067-1 FLAT PATTERN



D3067-1 BEND DETAIL

D3067-1 END PLATE

- 1) MACHINE PER DWG FILE "D3067-1.SLDPRT"
- 2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063)
OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063)
ALUMINUM SHEET, 0.063 THICK
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY
S. T. E. MENDMENT
S. T. E. MOL NOTICE

WORK ORDER

NO. 24097

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 18, 2005
10:59 am

Work Order No	:	0024097	Department Code:	
Project Name	:	D3067-1	Burden Flags	: NNNNNNN
Project For	:	WK540	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D3067-1	Invoice Number	:
Description	:	End Plate	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	160		
Amount Done	:	0	Order Entry No	:
Start Date	:	08-17-05	OE Value	: 0.00
Est Finish Date	:		Est Mark Up	: 0.000%
Act Finish Date	:		Actual Mark Up	: 0.000%
Drawings Reqd	:	No		
Ok for Approval	:			
Approval Rec'd	:		\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden	: 0.00	0.00	0.00		
<hr/>					
Total Cost	: 0.00	0.00	0.00		
Mark up	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00